

Date: Friday, 01/05/2009 11:19:37 AM  
 User: Linda Lacelle

## Process Sheet

|                       |  |                  |                               |
|-----------------------|--|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services    | Drawing Name     | : STEP SPACER                 |
| Job Number            | : 47644B                                 |                  |                               |
| Estimate Number       | : 10354                                  |                  |                               |
| P.O. Number           | :  | Part Number      | : D2322                       |
| This Issue            | : 01/05/2009 S.O. No. :                  | Drawing Number   | : D2322 REV C                 |
| Prsht Rev.            | : NC                                     | Project Number   | : N/A                         |
| First Issue           | : / / Type : SMALL /MED FAB              | Drawing Revision | : C                           |
| Previous Run          | : 44293B                                 | Material         | :                             |
| Written By            | :  | Due Date         | : 10/05/2009 Qty: 10 Um: Each |
| Checked & Approved By | : <u>JLD 09-05-01</u>                    |                  |                               |
| Comment               | : Est Rev:A New Issue 05-11-07 JLM       |                  |                               |
|                       | : Est Rev:B Now on Waterjet 06-07-03 JLM |                  |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.1315 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2322  
 Batch: 111381 B 9-5-6

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2322  
 Dwg Rev: C B 9-5-6  
 Prog Rev: C

(14)

2-Deburr if necessary B 9-5-6

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

509/05/07 (14)

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE  
 Form as per Dwg D2322

509/05/11 (14)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 47644B

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/11 (X14)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD/FL

09/05/11

(X14)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

91

09-05-11 (X14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Muffin

9/5/11

(14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12

Job Completion



MF 09-05-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>BW     | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA       |                        |
| CHECKED<br>KE    | APPROVED<br>[Signature] | DRAWING NO.<br>D2322                                    | REV. C<br>SHEET 1 OF 1 |
| DATE<br>98.09.29 | TITLE<br>STEP SPACER    |   | SCALE<br>1:2           |
| A                | 94.10.14                | NEW ISSUE   |                        |
| C                | 98.09.29                | 4.428 WAS 4.460, 0.040 WAS 0.032<br>CHANGES PER NCR 001 |                        |

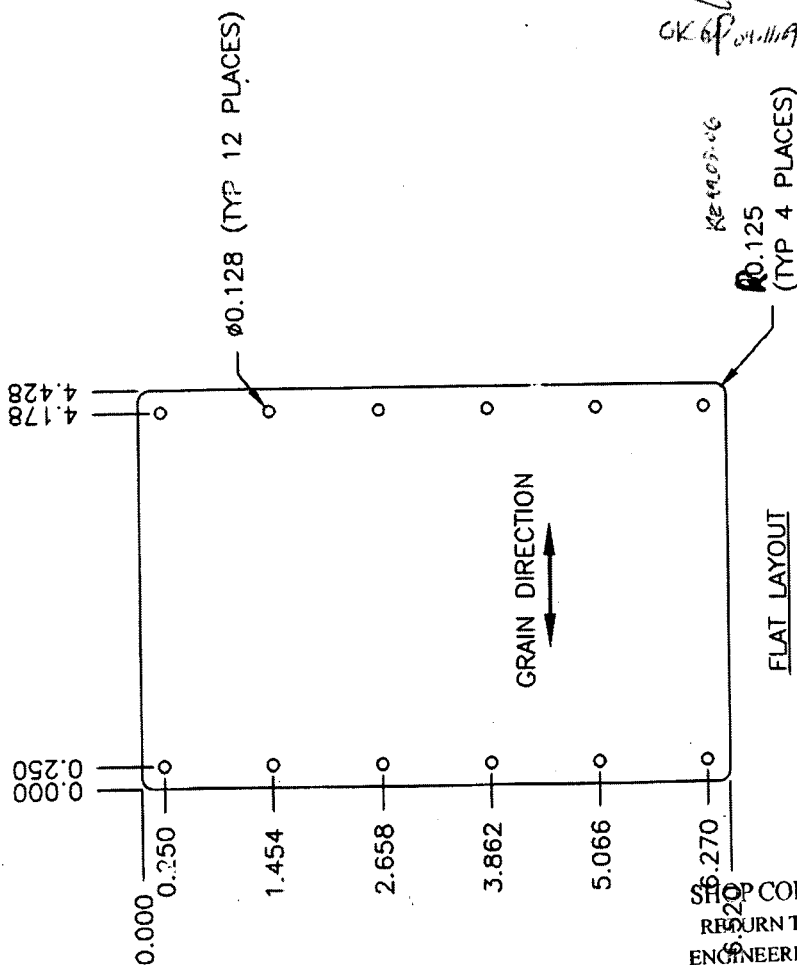
RELEASED  
98.10.28 DS

UNDER REVIEW

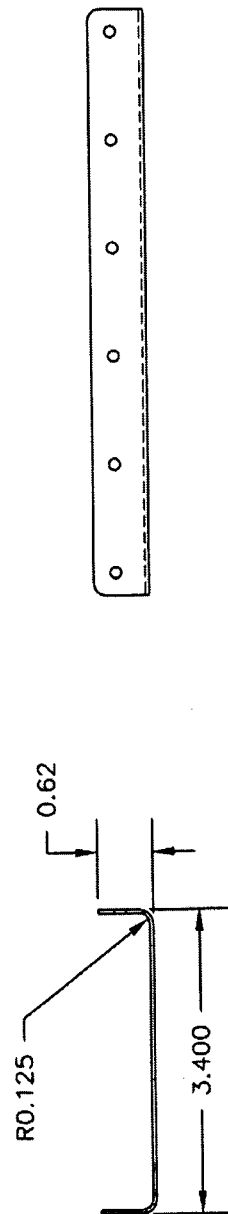
01.03.15 CP

DESIGN OK, BUT CHECK WITH  
DJS BEFORE MANUFACTURE

OK CP 01.11.19



STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. [Signature]



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED